



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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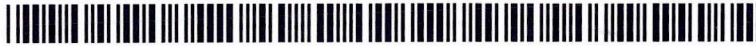
RBE-350DAMPER-05 Job Sheet 194518



Part No: RBE-350DAMPER-05

Job Qty: 16 pcs

Part Name: Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/3/19

Job Tracking No:

Due Date: 6/14/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE-350DAMPER REV:1 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Conventional Lathe - 1	16 pcs	6/14/19	6/14/19	0.50	1.60	Conventional Lathe - 1		DAS 71 9-89 19-5-22
							Conventional Lathe - 2		
110	QC 2	16 pcs	6/14/19	6/14/19	0.00	0.00	QC 2 - 1		DAS 71 9-89 19-5-22
							QC 2 - 12		
							QC 2 - 14		DAS 71 9-89 19-5-22
							QC 2 - 17		
							QC 2 - 19		DAS 71 9-89 19-5-22
							QC 2 - 2		
							QC 2 - 20		DAS 71 9-89 19-5-22
							QC 2 - 22		
							QC 2 - 23		DAS 71 9-89 19-5-22
							QC 2 - 25		
							QC 2 - 32		DAS 71 9-89 19-5-22
							QC 2 - 33		
							QC 2 - 35		DAS 71 9-89 19-5-22
							QC 2 - 39		
							QC 2 - 4		DAS 71 9-89 19-5-22
							QC 2 - 40		
							QC 2 - 44		DAS 71 9-89 19-5-22
							QC 2 - 45		
							QC 2 - 48		DAS 71 9-89 19-5-22
							QC 2 - 49		
							QC 2 - 50		DAS 71 9-89 19-5-22
							QC 2 - 51		
							QC 2 - 52		DAS 71 9-89 19-5-22
							QC 2 - 57		
							QC 2 - 62		DAS 71 9-89 19-5-22
							QC 2 - 63		
							QC 2 - 8		DAS 71 9-89 19-5-22
							QC 2 - 66		
							QC 2 - 64		DAS 71 9-89 19-5-22



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CANADA
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Container No: S182778



Part: RBE-350DAMPER-05

Job No: 194518

Serial No/Batch: S182778

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 05/22/19

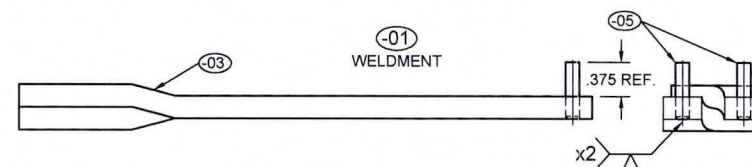
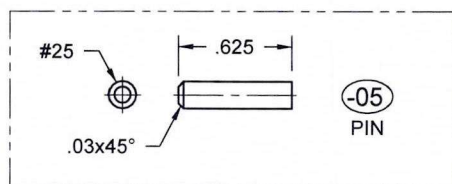
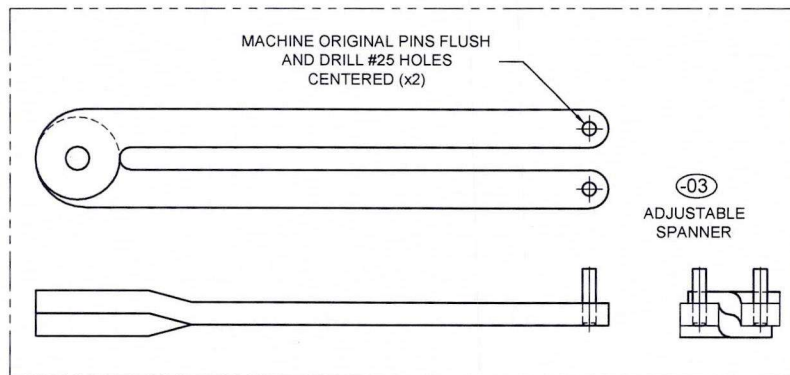
120 QC 8	16 pcs	6/14/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	OK 19/05/23
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Packaging 3-1 - Stock - B4B	16 pcs	6/14/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	2
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	16 pcs	6/14/19	0.00 0.00	QC 21 - SA - 21	DAG
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-59
Part Op 100 - (Manufacture as per dwg), 1-Machine as per folio FB _____ FOLIO REV: _____ DWG REV: _____ Descriptions: _____ 2-Debur 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: _____), IDENTIFY AND STOCK 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
3009A237	Pin	4 Ea (.25 ea)	100-Conventional Lathe - 1	S16/545 GA060	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Conventional Lathe - 1	3009A237	4	4	0	
Part Specifications					
Specifications could not be found.					

Plex 5/3/19 12:37 PM Dart.lajeunesse.marie

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REVISIONS				DATE	INITIAL	APPROVED
REV	DESCRIPTION					
1	DESIGNED PER HELI PRODUCTS TOOLS.			9/9/09	WP	DW



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194518 HUS
190506

FUNCTION: USED TO REMOVE DAMPER CAP

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-01	1	WELDMENT		
	1	MACH	-03		ADJUSTABLE SPANNER	FORGED STEEL	MCMaster-CARR #5481A1
	2	MACH	-05		PIN	DRILL ROD	#25 MCMaster-CARR #3009A237
	ASSY -01						

RED BARN MACHINE	
TITLE DAMPER SPANNER WRENCH	
DWG NO. RBE-350DAMPER	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9-9-09
SHEET 1 of 1	

DRAWN BY: PERRITT
APPROVED: *D. Weil*
HEAT TREAT: BLACK OXIDE
FINISH SPEC: USED ON MODEL
EUROCOPTER AS350/355

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

